



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3066-1

Job Sheet 180479



Part No: D3066-1

Job Qty: 100 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/6/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:B Now M6061-T6 06-06-23 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	100 Ea		8/3/18	0.00	0.00	Start Up Waterjet		SC 18/07/09
100	Waterjet	100 pcs		8/3/18	0.00	3.56	Waterjet1		SC 18/07/09
120	QC	100 pcs		8/3/18	0.00	0.00	QC8		38
130	HandFinish	100 pcs		8/3/18	0.00	1.53	HandFinish1		SA 18-07-11
140	QC	100 pcs		8/3/18	0.00	0.00	QC7-2		38
150	Packaging	100 pcs		8/3/18	0.00	0.00	Packaging3		DML 18-07-12
160	QC21-SA	100 Ea		8/3/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D3066
Descriptions: 150 - *** STOCK IN STEP CELL***

DAS
53
9-80

JUL 13 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	9.4500 sf (.0945 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.080	9	251	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.128inches + 0.005 - 0.000	0.133 0.128	0,129	
2	Spacer	0.708inches ± 0.010	0.718 0.698	0,710	
3	Spacer	0.354inches ± 0.010	0.364 0.344	0,355	
4	Spacer	0.354inches ± 0.010	0.364 0.344	0,356	
5	Spacer	2.250inches ± 0.005	2.255 2.245	2,252	
6	Spacer	16.450inches ± 0.010	16.460 16.440	16,450	
7	Spacer	0.080inches ± 0.010	0.090	0,080	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Disposition 				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	

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Container No: S090186
 Part: D3066-1
 Job No: 180479
 Serial No/Batch: S090186
 Revision:
 Inspector:
 Exp Date:
 Instructions:

Environment	☐
Design	☐
Doc/Data	☐
Equip/Tooling	☐
Handling/Pr	☐
Material	☐
Internal Transport	☐
Tribal Knowledge	☐
LOA	☐
Substation	☐
Past Expiry Date	☐
Misidentified	☐

Poor Information	☐
Rushing	☐
Product Improvement	☐
Process Improvement	☐
Manufacturing Process	☐
Past Due	☐

Crushing	☐
Heat Treat	☐
Wave/Twist in Tube	☐
Marks/Chatter	☐
OTHER :	☐

Countersink	☐
Cut Too Short	☐
Instructions Incomplete/Unclear	☐
Drill Holes	☐

ORY

☐	Power Loss/Surge	☐	Positioned Wrong
☐	Folio/Program	☐	Outside Dimensions
☐	Grain	☐	Over/Under tolerance
☐	Weld	☐	Part Incorrect
☐	Wrong Stock Pulled	☐	Part Lost/Missing
☐	Out of Sequence	☐	Part Moved
☐	Off-set	☐	Drawing
☐	Mislabeled	☐	Finish
☐	Fit/Function	☐	Misread
☐	Misaligned/off center	☐	Turning Sequence

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					